

Date: Tuesday, 3/11/2008 7:51:39 AM
 User: Kim Johnston

Process Sheet

14

Customer:	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW
Job Number	: 37719		
Estimate Number	: 12701		
P.O. Number	:	Part Number	: D119647011
This Issue	: 3/11/2008 S.O. No. :	Drawing Number	: D3034 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 30619	Material	:
Written By	:	Due Date	: 4/5/2008
Checked & Approved By	:	Qty:	53 Um: Each
Comment	: Est Rev:A New Issue 07-02-02 JLM Est Rev:B Update Step 7.0 07-07-28 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPP D119-647-011 CHG 002

08/04/21 08/03/25

2.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 4.2284 sf(s)/Unit Total : 12.6851 sf(s)
 UHMW 1" Black 28.75" X19.50"
 Batch: 15 107067

SA

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA148 Rev: A1 & Dwg D3034 Rev: A

2-Deburr per dwg D3034

SA 08/04/20

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/04/20

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 08/04/21 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW

Job Number: 37719

Part Number: D119647011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 0.4809 f(s)/Unit Total: 1.4427 f(s)

Rubber Cushion (6x 5.5")

Batch:

35769

AS

08/04/21 (X3)

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)

Radius Block

Batch:

B36624

AS

08/04/21 (X3)

9.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)

Washer

Batch:

B37210

AS

08/04/21 (X3)

10.0

D2947

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total: 18.0000 Each(s)

Clamp

Batch:

B32859

AS

08/04/21 (X3)

11.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)

Bolt

Batch:

M107321

AS

08/04/21 (X3)

12.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)

Washer

Batch:

M107321

AS

08/04/21 (X3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:51:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW

Job Number: 37719

Part Number: D119647011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Nut

Batch:

M106825

AS

08/04/21

(XS)

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/21

(E3)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119-647-011

Location:

PPP Rev:

RWB

8/4/21

SCP

(34)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion:



mf 08-04-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

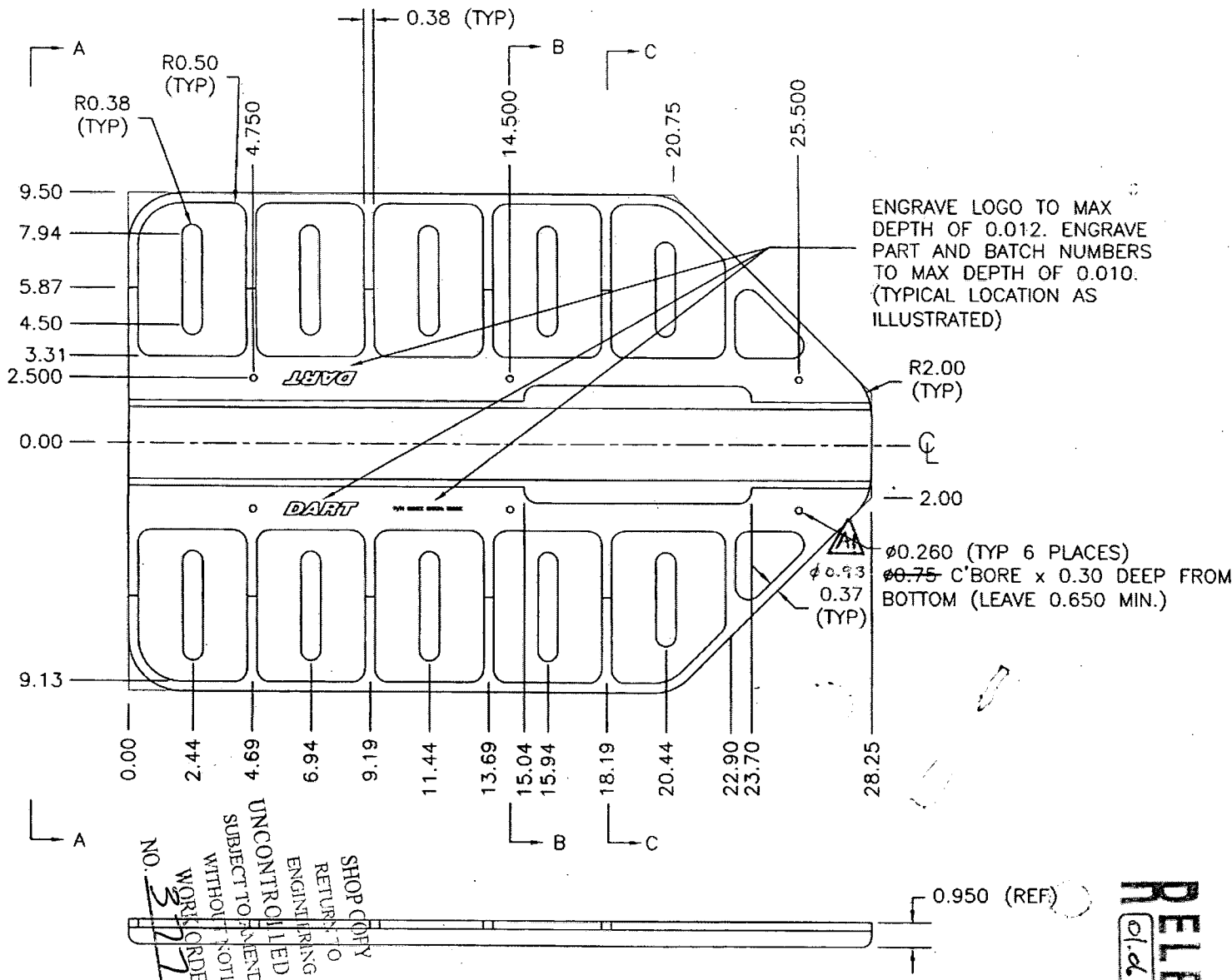
DART



DESIGN		DRAWN BY		DART AEROSPACE USA, INC.	
17		CP		PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.		REV. A	
		D3034		SHEET 1 OF 2	
DATE		TITLE		SCALE	
01.06.21		BEARPAW		1:6	
A		NEW ISSUE			

RELEASED
01.06.26

A1 03 01.06 0.93 WAS 0.75

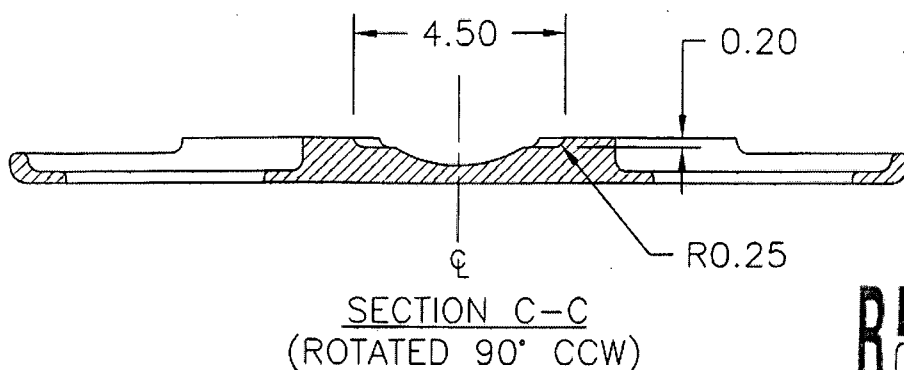
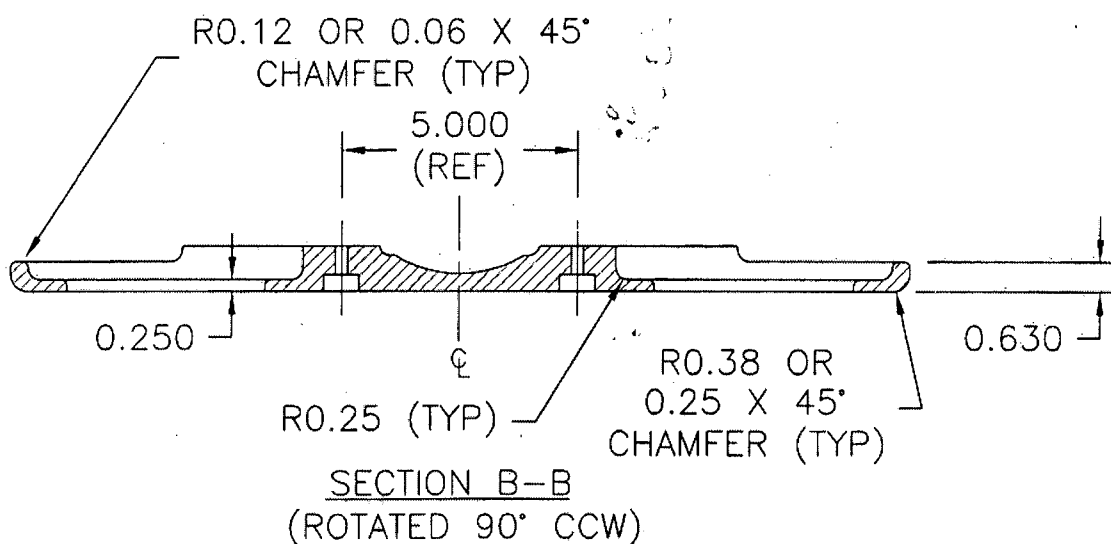
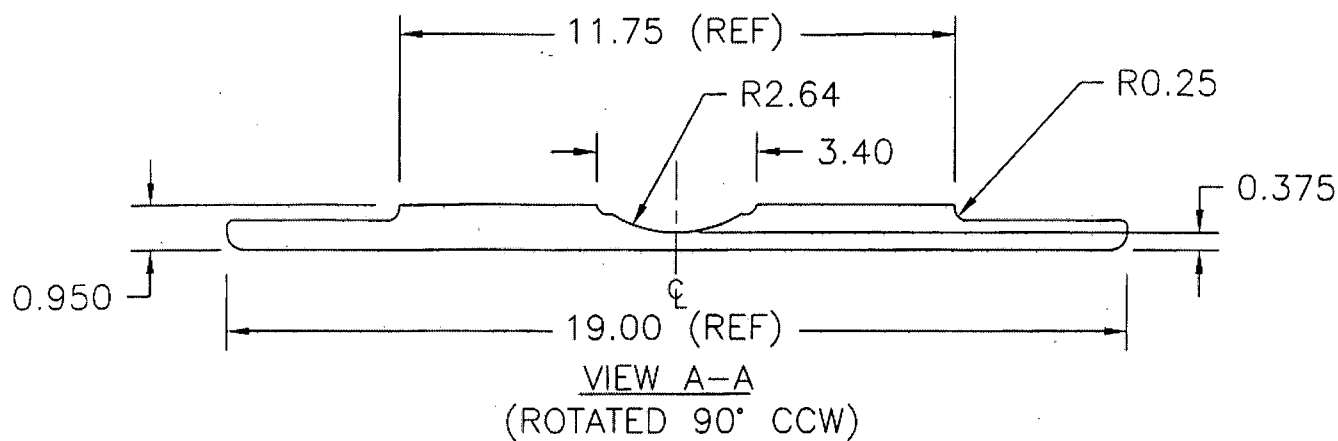


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WITHOUT NOTICE
WORK ORDER
NO. 30719

D3034-1
BEARPAW IS SYMMETRIC ABOUT CENTERLINE (EXCEPT FOR ENGRAVING)
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN #	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3034	REV. A SHEET 2 OF 2
DATE 01.06.21		TITLE BEARPAW	SCALE 1:4



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WORK ORDER
NO. 37419

RELEASED
a.d. 26

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D3034DART AEROSPACE LTD		Work Order: 3779
Description: Bearpaw		Part Number: D3034-1
Inspection Dwg: D3034	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype


Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	11.75	+/-0.030	11.75	/		
B	3.40	+/-0.030	3.40	/		
C	19.00	+/-0.030	19.00	/		
D	0.375	+/-0.010	.378	/		
E	0.950	+0.030/-0.010	.955	/		
F	0.06 x 45°	+0.030/-0.010	.06 x 45°	/		
G	0.25 x 45°	+/-0.030	.25 x 45°	/		
H	R0.25	+/-0.030	R.25	/		
I	0.630	+/-0.030	.621	/		
J	0.250	+/-0.010	.255	/		
K	4.50	+/-0.030	4.50	/		
L	0.20	+/-0.030	.190	/		
M	Ø0.260	+0.005/-0.000	Ø.260	/		
N	Ø0.93	+/-0.030	Ø.928	/		
O	0.30	+0.030/-0.000	.305	/		
P	28.25	+/-0.030	28.25	/		
Q	0.37	+/-0.030	.378	/		
R	4.750	+/-0.030	4.750	/		
S	9.750	+/-0.010	9.750	/		
T	11.000	+/-0.010	11.000	/		
U	8.66	+/-0.030	8.66	/		
V	5.000	+/-0.010	5.000	/		

Measured by: SA	Audited by: SP	Prototype Approval: N/A
Date: 08/04/20	Date: 08/04/21	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D119-647-011	KJ/RF	

Date: Monday, 08/09/2008 12:55:08 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D119-647
Job Number	: 41884		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: ECN30
This Issue	: 08/09/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: ECN08-519
First Issue	: 08/09/2008	Project Number	:
Previous Run	: 00015	Drawing Revision	:
	Type : MACHINED PARTS	Material	:
Written By	: 	Due Date	: 15/09/2008
Checked & Approved By	:	Qty:	1
Comment	:	Um:	Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK AND ADD NEW PAPERWORK
 PER ECN 08-518, FAA STC SR00949SE

D119-647-011

37719

RETURN TO STOCK

8/9/10

ASD

2.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/10

Job Completion



u 08/09/10